



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

001719

K10004

Job Sheet 173830



Part No: K10004

Job Qty: 1 ea

Part Name: Heavy Duty Saddles



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 3/30/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E IPP : D 05.07.22 Reformat; Added D3428-3 per CHG003 KJ/JLM IPP Rev:E 08-09-29 revD as per dwg DD verified by: IPP Rev:F chg005 DD 10.06.03 verf:JLM IPP REV:G 13.08.21 REMOVED D3428-3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/30/18	3/30/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 21 2018
105	Packaging	1 pcs	3/30/18	3/30/18	0.00	0.00	Packaging1-5		MAR 21 2018
110	QC	1 pcs	3/30/18	3/30/18	0.00	0.00	QC4		Sms
115	DC	1 pcs	3/30/18	3/30/18	0.00	0.00	DC		Sms
120	Packaging	1 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3-2		Sms
130	QC21-FG	1 Ea	3/30/18	3/30/18	0.00	0.00	QC21		MAR 27 2018

Part Op 115 - Photocopy bluefile for K10004, D205-594-011/-013/-015 & D412-652-011/-21 and type labels per PPP K10004
Descriptions: CHG005

120 - Location : FG129

fg129

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-51A	Bolt	16 Ea (16 ea)	90-Start up Operation	
AN5-15A	Bolt	32 Ea (32 ea)	90-Start up Operation	
AN5-36A	Bolt	2 Ea (2 ea)	90-Start up Operation	
AN5-42A	Bolt	2 Ea (2 ea)	90-Start up Operation	
AN5-43A	Bolt	2 Ea (2 ea)	90-Start up Operation	
AN5-45A	Bolt	2 Ea (2 ea)	90-Start up Operation	
D205-641-011	Ground Handling Lugs	2 Ea (2 ea)	90-Start up Operation	
D2570	Bushing	32 Ea (32 ea)	90-Start up Operation	
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	
D5951	Saddle	2 Ea (2 ea)	90-Start up Operation	
D5953	Saddle	2 Ea (2 ea)	90-Start up Operation	
D5955	Saddle	2 Ea (2 ea)	90-Start up Operation	
D5957	Saddle	2 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (16 ea)	90-Start up Operation	
MS21042L5	Nut	40 Ea (40 ea)	90-Start up Operation	
MS21043-4	Nut	2 Ea (2 ea)	90-Start up Operation	
NAS1149D0563J	Washer	80 Ea (80 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec./Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		342) Approval	
Description Work Order Deviation		Disposition			
Part: K10004 Job No: 173830 Serial No/Batch: S052910 Revision: Inspector: Container No: S052910 DART AEROSPACE DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 532-5200 Email: sales@dartaero.com www.dartaerospace.com					
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	P ☐ Fi ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Ied Wrong ☐ Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Date: 03/20/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-51A	16	254	0
	AN5-15A	32	49	0
	AN5-36A	2	296	0
	AN5-42A	2	16	0
	AN5-43A	2	26	0
	AN5-45A	2	12	0
	D205-641-011	2	0	0
	D2570	32	799	0
	D3407-041	2	26	0
	D3417-5	4	21	0
	D3456-1	2	81	0
	D5951	2	3	0
	D5953	2	4	0
	D5955	2	2	0
	D5957	2	3	0
	MS21042L4	16	3,748	0
	MS21042L5	40	837	0
	MS21043-4	2	863	0
	NAS1149D0563J	80	1,270	0
Part Specifications				
Specifications could not be found.				

Plex 3/7/18 1:51 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001719	S052055	AN4-51A	Bolt	S044185	ST340	16
001719	S052053	AN5-15A	Bolt	FM138333-0	ST337	32
001719	S052050	AN5-36A	Bolt	S041116	ST336	2
001719	S052048	AN5-42A	Bolt	FM138607	ST336	2
001719	S052047	AN5-43A	Bolt	S001514	ST336	2
001719	S052046	AN5-45A	Bolt	FM137878-2	ST335	2
001719	S052044	D2570	Bushing	s046933	ST008	32
001719	S043180	D3407-041	Tow Ring	S043178	ST530	1
001719	F165371-1	D3417-5	Washer		ST034	4X
001719	S052029	D3456-1	Washer	s012112	ST036	2
001719	S052027	D5951	Saddle	s019457	ST399	2
001719	S052028	D5953	Saddle	s020680	ST399	2
001719	S020222	D5955	Saddle	F165289	ST399	2
001719	S052026	D5957	Saddle	s021031	ST399	2

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

M521042L5 S016880 40X
M521043-4 S038086 2X
N451149D0563J S025743 80X

Plex 3/16/18 8:37 AM Dart.joly.jocelyne

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING LANDING GEAR INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 412	D412-652-011 D412-652-021
BELL 205/212/214	D205-594-011 D205-594-013 D205-594-015
BELL 204	D205-594-021 D205-594-023

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10004	D412-652-011 D412-652-021	D205-594-011 D205-594-013 D205-594-015 D205-594-021 D205-594-023
D205-641-011	2	2	2
D2570	32	32	32
D3407-041	2	2	2
D3417-5	4	4	4
D3428-3*	1	N/A	1
D3456-1	2	2	2
D5951	2	2	2
D5953	2	2	2
D5955	2	2	2
D5957	2	2	2
AN4-51A	16	16	16
AN5-15A	32	32	32
AN5-36A	2	2	2
AN5-42A	2	2	2
AN5-43A	2	2	2
AN5-45A	2	2	2
AN960JD516	80	80	80
MS21042-4 (OR L4)	16	16	16
MS21042-5 (OR L5)	40	40	40
MS21043-4	2	2	2

*REQUIRED WITH D205-594-011/-013 INSTALLATIONS ON 214 AIRCRAFT ONLY

E	D3407-041 WAS D3407-045; REMOVE D3812-1; REASON: TOW RING IS CHANGED ON D205-634-011/ D204-635-011 SKIDTUBES @ CHG 007 AND D205-634-015 SKIDTUBES @ CHG 006. SEE DSI 9417/9418 @ REV. B	PH	09.01.28
D	D3407-045 WAS D2707-041; D3456-1 WAS AN970-4; MS21043-4 REPLACES MS21042-4 (QTY 2); ADD D3417-5 AND D3812-1; ADD REFERENCE TO D205-594-021/-023	PH	08.09.11
C	ADD D3428-3 PLACARD	PH	05.07.22
B	ADD D2707-041 OPTION	DS	00.11.22
A	NEW ISSUE	DS	00.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		K10004	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SADDLE KIT	NTS
DATE	09.01.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	